

Ship Friday!

Rev BS 13/11/15
11/18/15

Work Order ID 109179

November-13-13 10:03:52 AM

109179

Page 1

Item ID: D4773-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 11/13/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: W Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4773

PB1

Rev B

W

110 Pick Kit 0.00

110

Packaging Memo 0.00

Packaging

2 13-11-14 MAL

120 0.00

120

Large Fab Memo 0.00

Large Fab

1- Weld hardcoat on bars as per dwg
A/R 2059b hardcoat Batch #: M126073

2- Weld bar to wearplate as per dwg
A/R s.s. rod Batch #: M126048

3- Weld shim as per dwg
A/R s.s. rod Batch #: M126048

4- Transfer drill drain holes as per dwg

2 13-11-14 MAL

Work Order ID 109179

109179

Page 2

November-13-13 10:03:52 AM

Item ID: D4773-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Assembly

Start Date: 11/13/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
130									DAS
QC	Memo	0.00				②	13-11-14		9
Quality Control									9-89
140	QC5- Inspect part completeness to step on W/O	0.00							DAS
140									9
QC	Memo	0.00				②	13-11-14		9-89
Quality Control									
150		0.00							
150									AS
Small Fab	Memo	0.00				②	∅	∅	13-11-14
Small Fab	Apply Rockguard on entire concave surface as per dwg								
	A/R Rockguard Batch: 127155								

Work Order ID 109179

November-13-13 10:03:52 AM

109179

Page 3

Item ID: D4773-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 11/13/13 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location:	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

13-11-15

2
Inspect as per
Rev PD1

ship

2x DAS 28 9-89 13-11-15

13/11/18

Release Dwg as per
Rev B

POSITIVE RECALL
EFFECTIVE 13/11/13 AUTH 6
DATE 13/11/15

Rev B

13-11-15

Picklist Print

November-13-13 10:03:52 AM

Page 1

Work Order ID: 109179
 Parent Item: D4773-041
 Parent Item Name: Wearplate Assembly

Start Date: 11/13/13
 Start Qty: 2.00

Required Date: 11/15/13
 Required Qty: 2.00

Comments: IPP REV:A 13.03.26 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4682-9 Wearplate Shim		Manufactured	No				Each	7.0000		2			
---------------------------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA001	7	
-------	---	--

100608	5	
--------	---	--

D4770-1 Bar		Manufactured	No				Each	6.0000		4			
----------------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

Location	Loc Qty	Loc Code
----------	---------	----------

WA001	6	
-------	---	--

105710	2	
--------	---	--

D4773-1 Wearplate		Manufactured	No				Each	0.0000		2			
----------------------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

106047	4	
--------	---	--

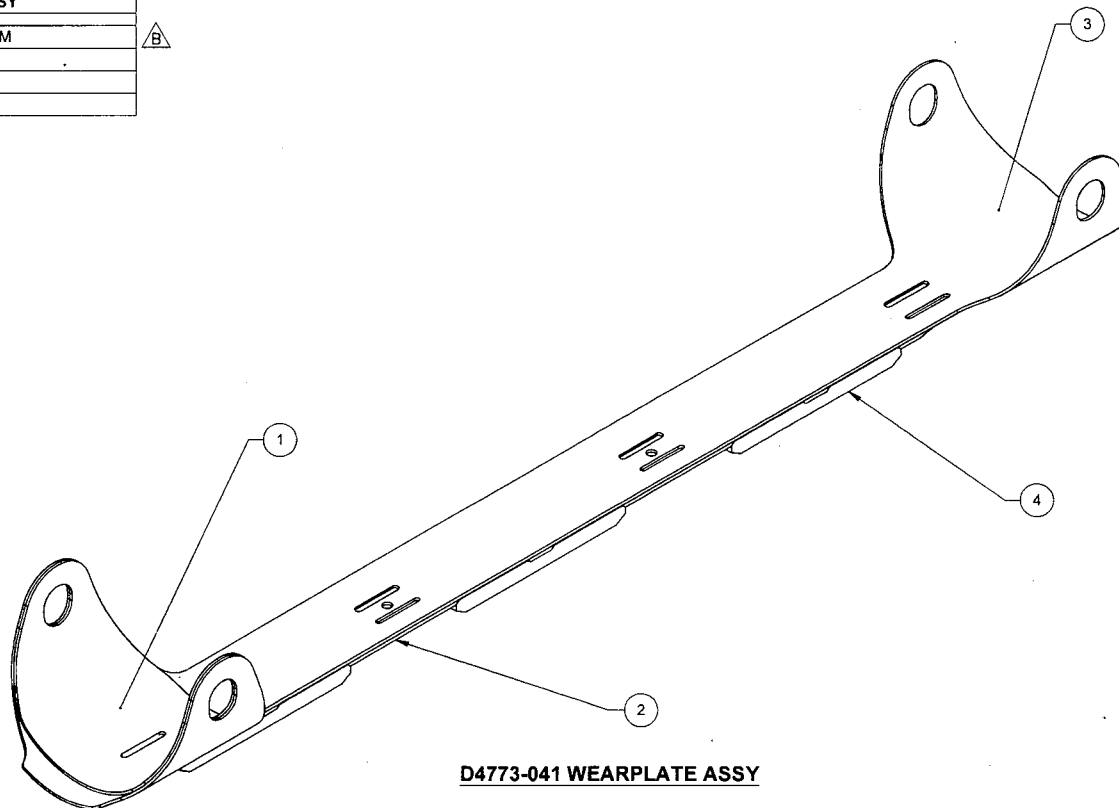
B109181 X2

13-11-14 MAL

13-11-14 MAL

13-11-14 MAL

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4773-041	WEARPLATE ASSY
1	1	D4682-9	WEARPLATE SHIM
2	2	D4770-1	BAR
3	1	D4773-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4773-041 WEARPLATE ASSY

B	D4682-9 WAS D4682-3, THRU HOLES NOW SLOTS. VARIOUS DIMENSIONAL CHANGES. UPDATED PART WEIGHTS.	DB	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D4773	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

D

C

B

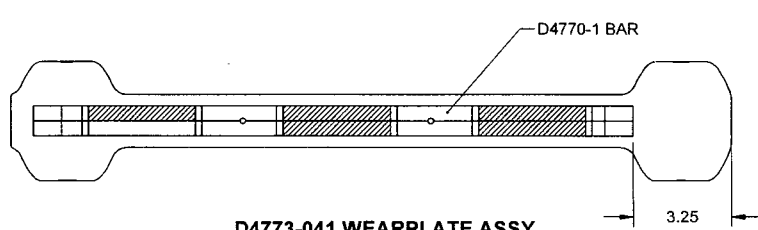
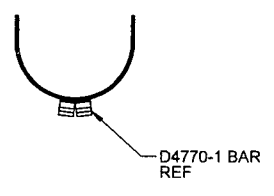
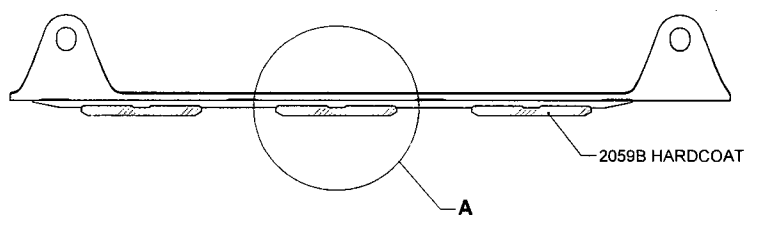
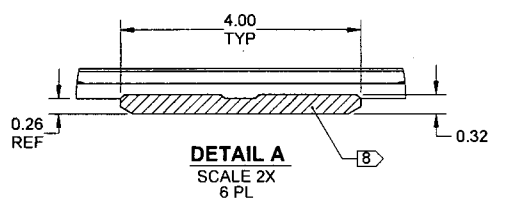
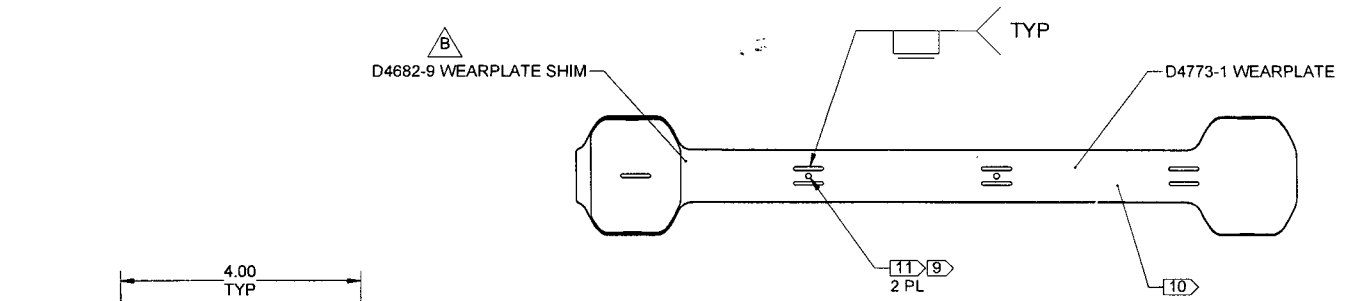
A

D

C

B

A



D4773-041 WEARPLATE ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4773-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 4.92 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL $\varnothing 0.188$ HOLE FROM D4773-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING PLUS ONE ROCKGUARD

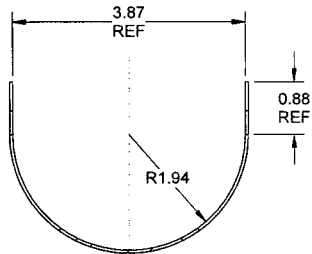
Rockguard - 4715
CP 13/10/14

DESIGN
 DRAWN
 CHECKED
 MFG. APPR.
 APPROVED
 DE APPR.
 DATE 13.08.08

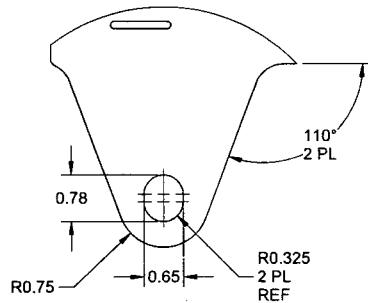
DB
 DB

DART AEROSPACE USA, INC.
 KENT, WA
 DRAWING NO.
D4773
 TITLE
WEARPLATE ASSY
 REV. PB2
 SHEET 2 OF 3
 SCALE
 NTS
COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

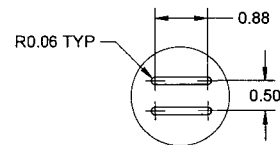
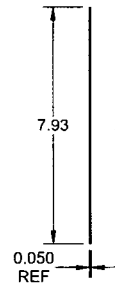
8 7 6 5 4 3 2 1



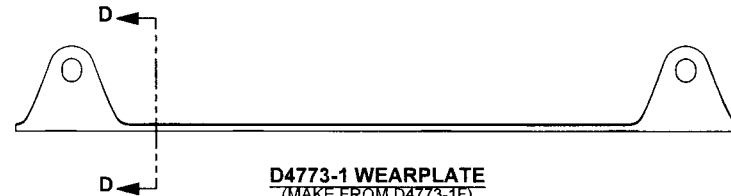
SECTION D-D
SCALE 2X



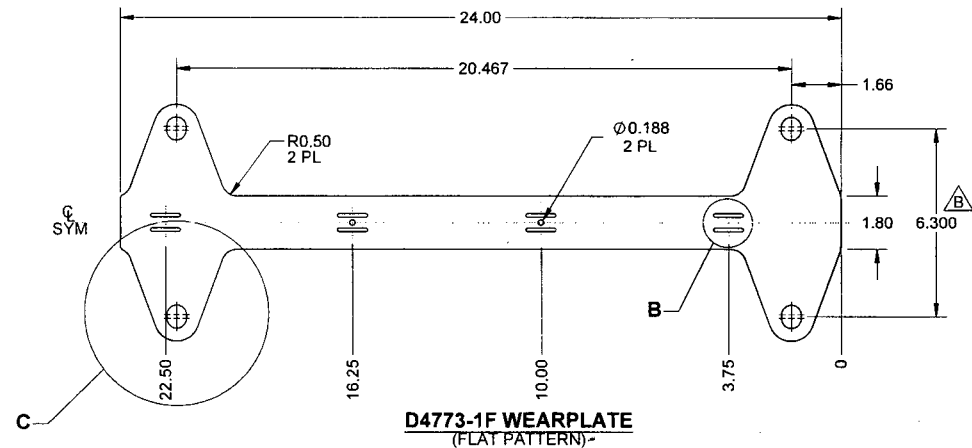
DETAIL C
SCALE 2X
4 PL



DETAIL B
SCALE 2X
4 PL



D4773-1 WEARPLATE
(MAKE FROM D4773-1F)



D4773-1F WEARPLATE
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4773-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.08.08

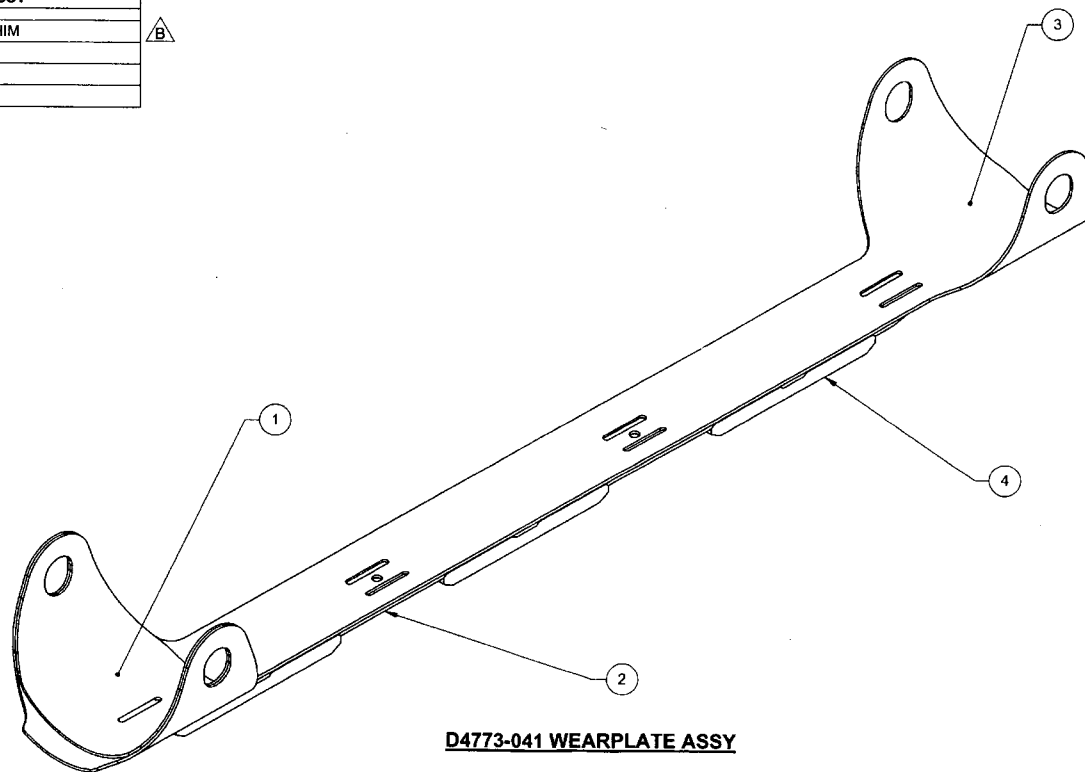
DB
DB

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. REV. PB2
D4773 SHEET 3 OF 3
TITLE SCALE
WEARPLATE ASSY NTS

COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4773-041	WEARPLATE ASSY
1	1	D4682-9	WEARPLATE SHIM
2	2	D4770-1	BAR
3	1	D4773-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4773-041 WEARPLATE ASSY

RELEASED
2013-11-13
W

DESIGN	DB	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DB</i>	D4773	SHEET 1 OF 3
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	WEARPLATE ASSY	NTS
DATE	13.08.08	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

D

D

C

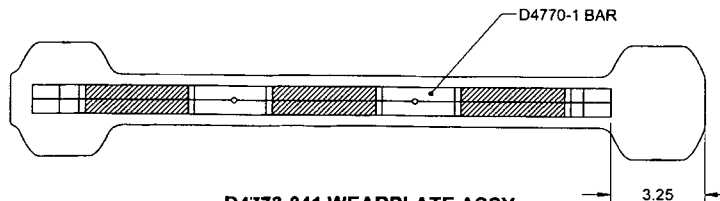
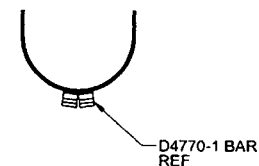
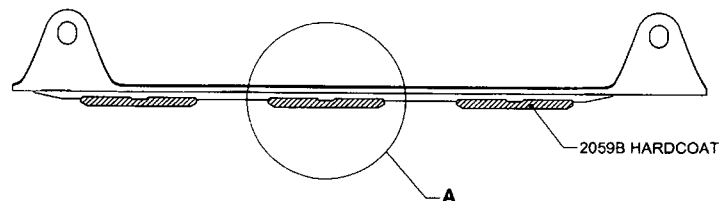
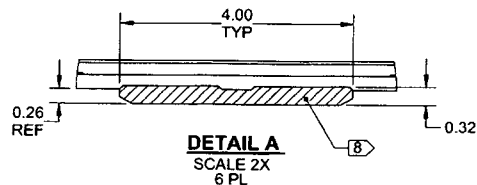
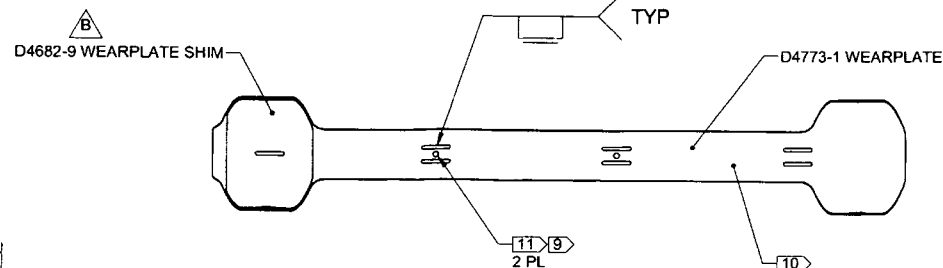
C

B

B

A

A



D4773-041 WEARPLATE ASSY

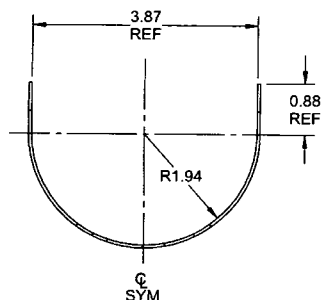
RELEASED
2013-11-13

NOTES:

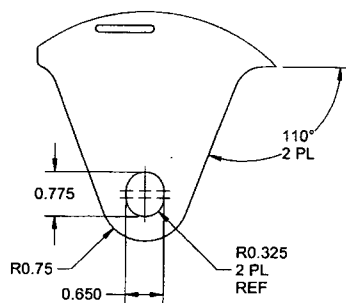
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4773-041" AND B/N PER QSI 044 METHOD 6.1
- 7) WEIGHT: 3.27 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
- 9) TRANSFER DRILL $\phi 0.188$ HOLE FROM D4773-1 WEARPLATE TO D4770-1 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\phi 0.188$ AFTER APPLYING PLUS ONE ROCKGUARD

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS	DRAWING NO. D4773	REV. B SHEET 2 OF 3
MFG. APPR.	ND	TITLE WEARPLATE ASSY	SCALE NTS
APPROVED	ND	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	ND		
DATE	13.08.08		

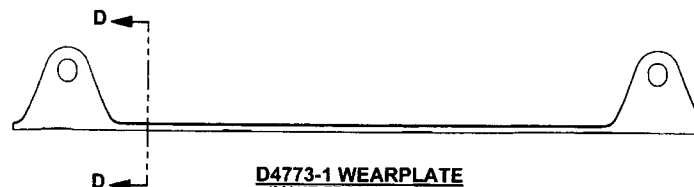
8 7 6 5 4 3 2 1



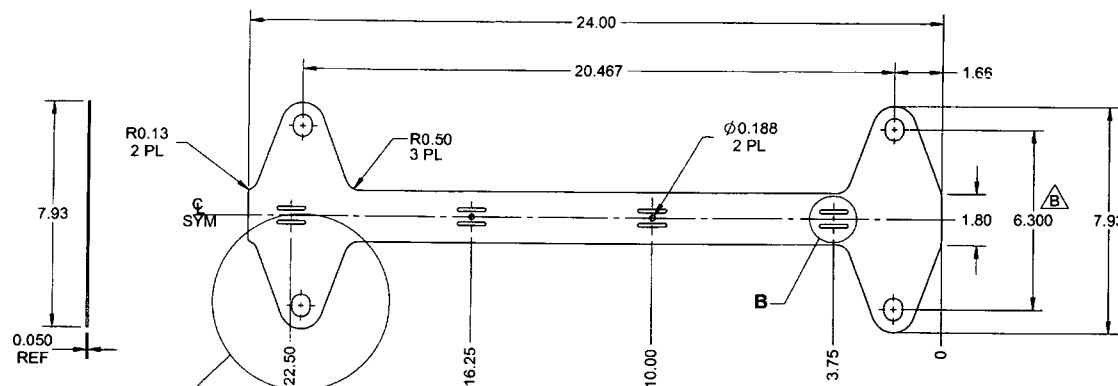
SECTION D-D
SCALE 2X



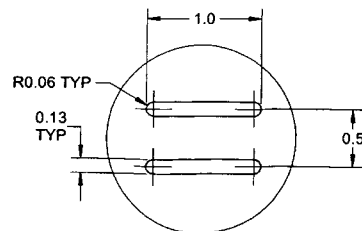
DETAIL C
SCALE 2X
4 PL



D4773-1 WEARPLATE
(MAKE FROM D4773-1F)



D4773-1F WEARPLATE
(FLAT PATTERN)



DETAIL B
SCALE 4X
4 PL

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4773-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

DESIGN	DB	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	<i>ASS</i>	DRAWING NO. D4773	REV. B SHEET 3 OF 3
MFG. APPR.	<i>AP</i>	TITLE WEARPLATE ASSY	SCALE NTS
APPROVED	<i>AP</i>	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DE APPR.	<i>AP</i>		
DATE	13.08.08		

RELEASED
2013-11-13